

x2 to Ship NOV. 15

Work Order ID 153185

153185

Page 1

Wednesday, November 09, 2016 9:51:14 AM

Item ID: D3796-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Wearplate Weldment
Start Date: 11/9/2016 Start Qty: 2.00 *2* 3
Required Date: 11/15/2016 Req'd Qty: 2.00 *2* 3
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: [Signature] Date: 11-11-09 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3796	B								

100 0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3796 Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

3

11/11/11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

2

11/11/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Wednesday, November 09, 2016 9:51:14 AM

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Item ID: D3796-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Wearplate Weldment

Stop

NS?

Start Date: 11/9/2016 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 11/15/2016 **Req'd Qty:** 2.00

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Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

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Item Name: Aft Wearplate Weldment
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Required Date: 11/15/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
160	Identify as per dwg & Stock Location: <u>8T 605</u>	0.00							
160									
Packaging	Memo	0.00							3x. NOV 15 2016 DAS 26 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							DAS 21 9-89
Quality Control									NOV 15 2016

**POSITIVE RECALL**EFFECTIVE 16/11/11 AUTH kmRELEASED 9 DATE 16-11-15

9-89

cannot ship until
material certs received.DAS
21
9-89

NOV 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Wednesday, November 09, 2016 9:51:22 AM

Page 1

Work Order ID: 153185

153185

Parent Item: D3796-043

D3796-043

Parent Item Name: Aft Wearplate Weldment

Start Date: 11/9/2016

Required Date: 11/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-08-05 new issue DD verified by:ec
IPP Rev:B 08-09-10 revA as per dwg (ecn 08-513) DD VERF:EC IPP REV:C
AS PER PB1 12-07-04 JLM VERIOFIED BY:DD IPP REV:D
12.09.06 PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.9550	1.912	4.025263			

M304S16GA

304/316 Sheet .063

2x 16 11 11

Location	Loc Qty	Loc Code
MAT010	128.955	
m135377	0.545	
m135559	0.85	
m135689	4.91	
m136036	122.65	

5.5

D4379-3

Manufactured No

130 Each 80.0000 12 24

D4379-3

Wearplate Cup

16-11-14
JMC

Location	Loc Qty	Loc Code
WA002	80	
135592	20	
141353	20	
150438	40	

78

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Description Work Order Deviation			Disposition																																																																				
			Completed By																																																																				
			Lead hand / Supervisor Approval Verification																																																																				
			QC / QA Coordinator Approval																																																																				
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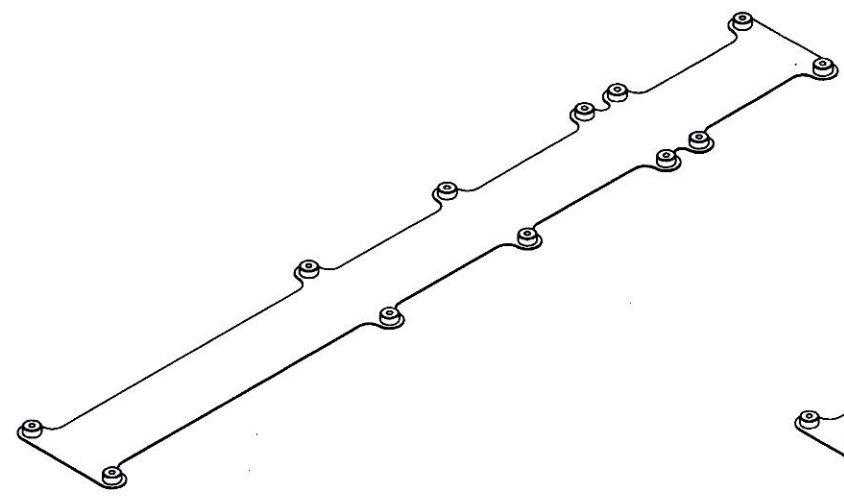
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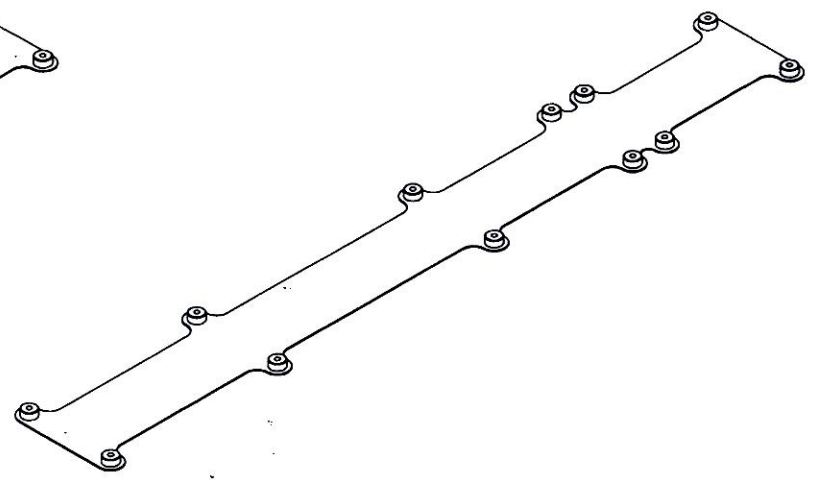
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D3796-041 FWD WEARPLATE WELDMENT



D3796-043 AFT WEARPLATE WELDMENT

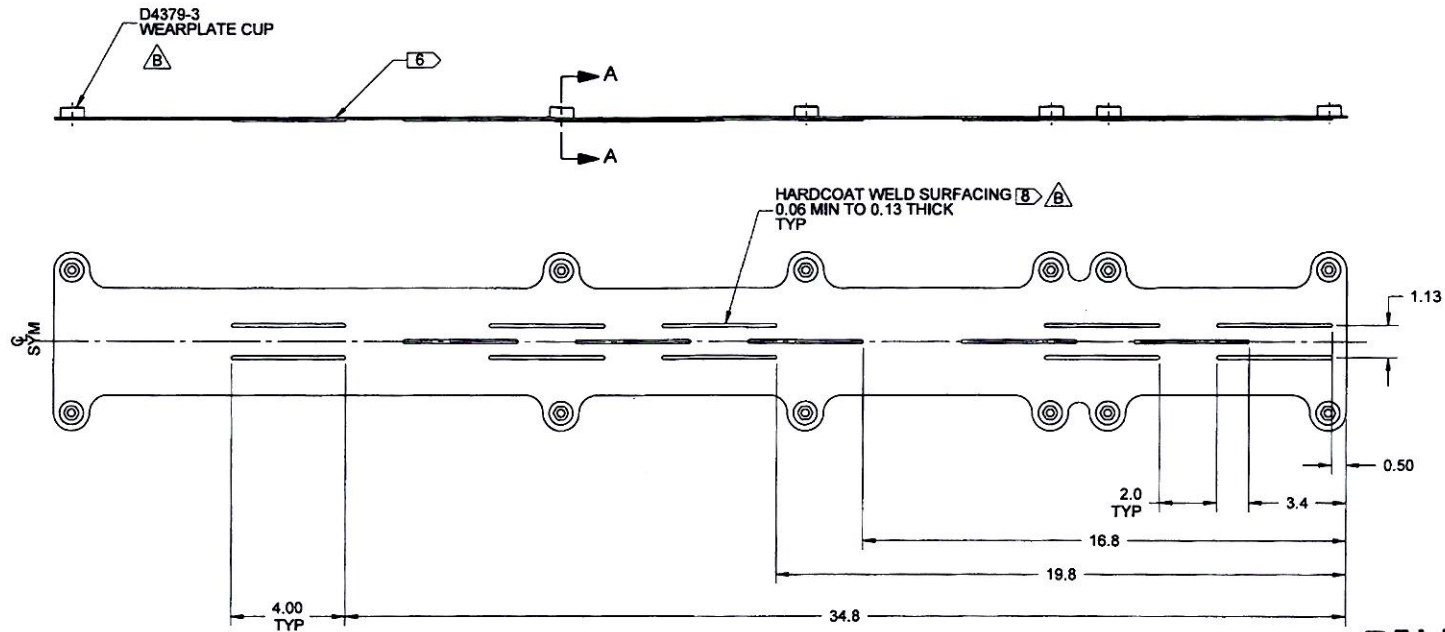
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
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NO. 153125
16-11-09 *[Signature]*

RELEASED
2012-08-10 *[Signature]*

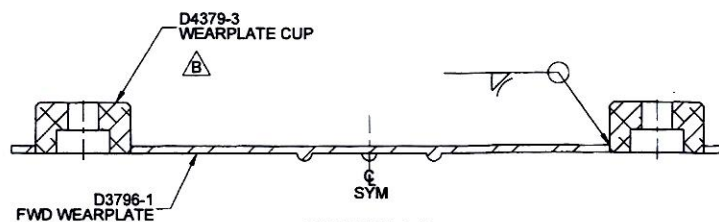
B	REPLACED D3009-3 CUP WITH D4379-3 WEARPLATE CUP; REMOVE REFERENCE TO 2059 HARDCOAT WELD SURFACING TO ALLOW ALTERNATIVE HARDCOAT MATERIALS PER OSI 004 (C4-2 & C5-3); REMOVE POWDER COAT FINISH NOTE 2 (SHEETS 2 & 3)		AP	12.07.04
A	NEW ISSUE		MB	08.08.01
REV.	DESCRIPTION		BY	DATE
DESIGN	MB	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3796	SHEET 1 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	412 SKI WEARPLATE	NTS	
DATE	12.07.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
X	D3796-041	FWD WEARPLATE WELDMENT
1	D3796-1	FWD WEARPLATE
12	D4379-3	WEARPLATE CUP



D3796-041 FWD WEARPLATE WELDMENT



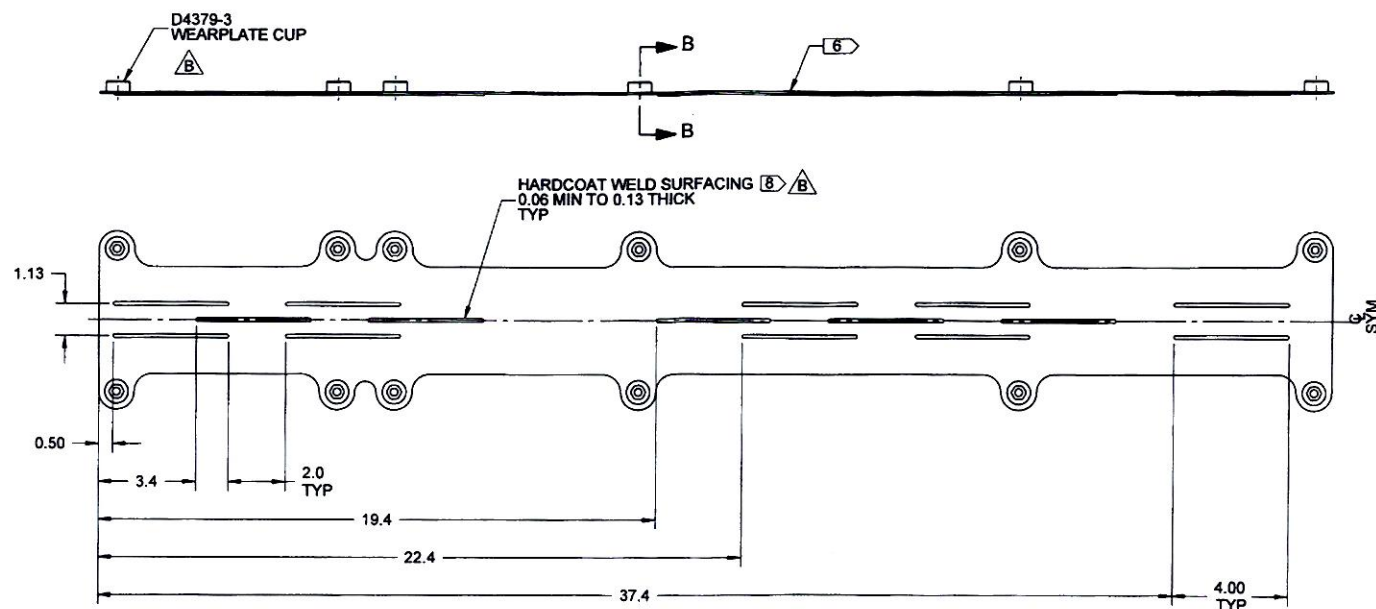
SECTION A-A
SCALE 4X, TYP

RELEASED
2012-08-10

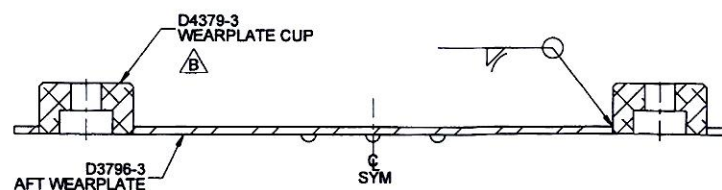
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 044
 - 7) WEIGHT: 4.00 lbs
 - 8) WELD PER DART QSI 004

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TP	DRAWING NO.	REV. B
MFG. APPR.	D	D3796	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
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QTY -043	P/N	DESCRIPTION
X	D3796-043	AFT WEARPLATE WELDMENT
1	D3796-3	AFT WEARPLATE
12	D4379-3	WEARPLATE CUP



D3796-043 AFT WEARPLATE WELDMENT



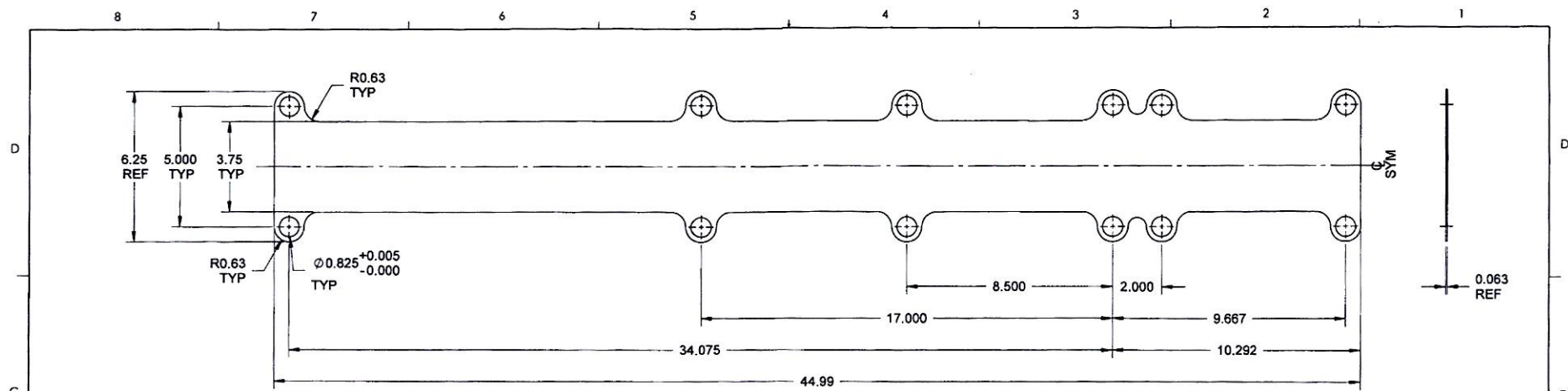
SECTION B-B D5-3
SCALE 4X, TYP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER PER QSI 044
 - 7) WEIGHT: 3.86 lbs
 - 8) WELD PER DART QSI 004

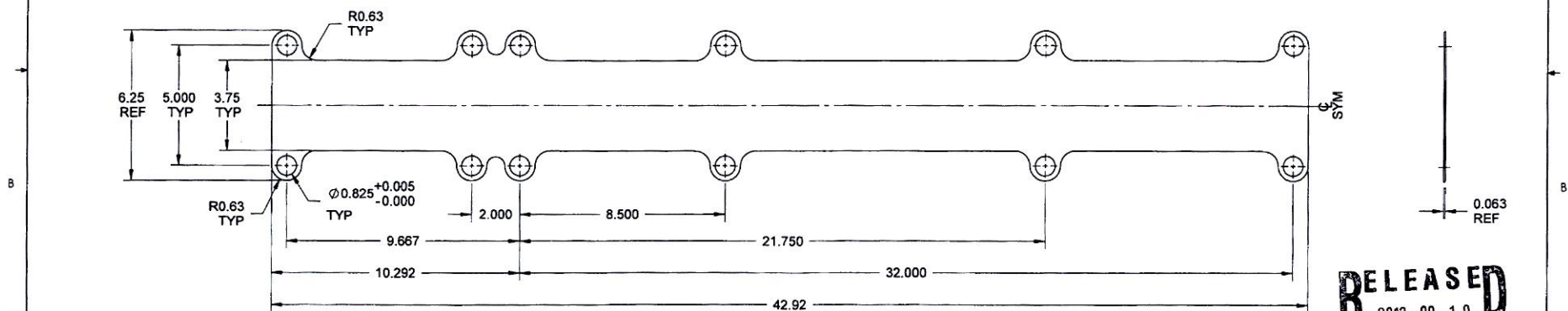
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MFG. APPR.	<i>[Signature]</i>	D3796	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 SKI WEARPLATE	NTS
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[Signature]



D3796-1 FWD WEARPLATE



D3796-3 AFT WEARPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK) PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240, REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3796-1 = 3.37 lbs
D3796-3 = 3.11 lbs

DESIGN	MB	DART AEROSPACE LTD	
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MFG. APPR.	D	D3796	SHEET 4 OF 4
APPROVED	142	TITLE	SCALE
DE APPR.	142	412 SKI WEARPLATE	NTS
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